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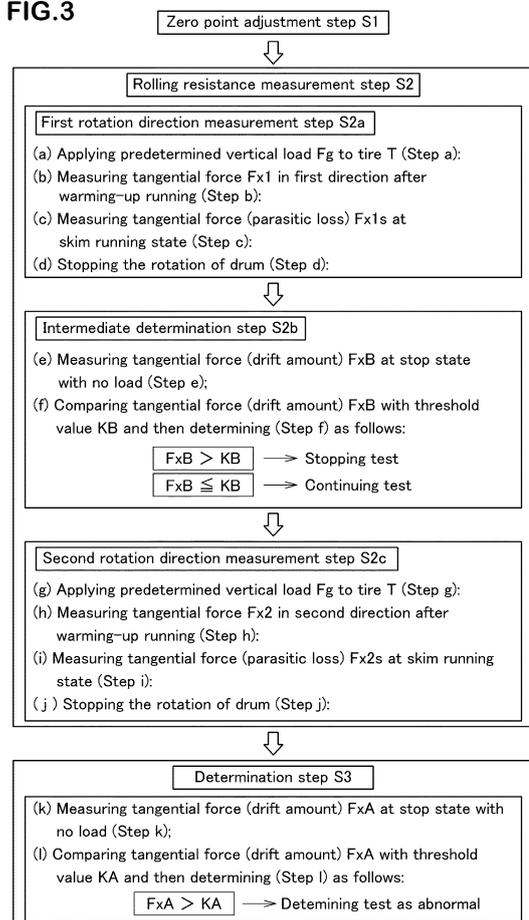
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(54) **TIRE ROLLING-RESISTANCE TESTING METHOD AND TESTING DEVICE**

(57) This invention improves the precision and reliability with which rolling resistance can be measured. This rolling-resistance testing method includes a rolling-resistance measurement stage and a determination stage. In the rolling-resistance measurement stage, a component force meter is used to measure the tangential axial force that occurs in a tire axle when the tire is rotated under load. In the determination stage, the axial force is measured in a no-load stopped state in which the tire has been separated from a drum, said axial force is compared to a threshold, and if the axial force is greater than said threshold, a determination that an anomaly has occurred in the test is made.

FIG.3



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Description**Technical Field**

5 **[0001]** The present invention relates to a tire rolling resistance testing method and testing device capable of improving measurement accuracy and reliability of rolling resistance.

Background Art

10 **[0002]** As one of test methods for measuring rolling resistance of a tire, a force method described in JIS D4234 is well known. In this method, as illustrated in FIG. 6, a tire T is rotated by being pushed against an outer surface of a drum (a) that rotates at a predetermined speed V (e.g., 80 km/h in case of passenger car tires) with a predetermined vertical load (e.g., 80% of the maximum load capacity in case of passenger car tires). Then a tangential force F_x acting on the tire axle (b) is measured by a force component meter attached to the tire axle (b), and then the rolling resistance F_r is calculated based on the tangential force F_x .

15 **[0003]** Note that the tangential force F_x includes resistance of a bearing on the tire axle and parasitic loss of the air resistance on the tire T and the drum (a). Accordingly, a correction of the axial force F_x takes place to remove the parasitic loss. Here, the parasitic loss is measured by the skim test (e.g., JIS D4234) which is performed subsequent to the measurement of the tangential force F_x .

20 **[0004]** On the other hand, the force component meter amplifies a signal obtained from a sensor by an amplifier because the signal is very weak. At that time, however, "drift" in which an operating point of the amplifier shifts occurs, and it brings a problem of divergence between the actual value and the displayed value. Drift is a phenomenon that an output of the amplifier varies gradually so as to shift the zero point in the state without the addition of input signals to the two input terminals. The reason for this can be found such as variations in the temperature characteristics of transistors.

25 **[0005]** In the prior art, drift amount of an amplifier to the time was previously obtained through actual measurement and stored. A technique that corrects a value of the tangential force F_x measured by offsetting the drift amount based on the information has been proposed. Unfortunately, the drift amount is different by not only a rotational direction of the tire at the time of measurement but also each tire. Thus, it has been difficult to correct the drift amount accurately from the tangential force F_x , and therefore a fully satisfactory accuracy has not yet been achieved.

30 **[0006]** The following Patent Document 1 relates to the correction of the drift amount.

Citation List

Patent Literature

35 **[0007]** Patent Document 1: Japanese Unexamined Patent Application Publication S56-51641

Summary of Invention

40 Technical Problem

[0008] The present invention has an object to provide a tire rolling-resistance testing method and testing device capable of improving the measurement accuracy and reliability of rolling resistance by identifying and excluding an abnormal measurement of rolling resistance value due to drift, based on measuring drift amount after completing measurement of a tangential force F_x , and comparing the drift amount with a previously determined threshold value KA.

Solution to Problem

50 **[0009]** The first aspect in accordance with the invention provides a tire rolling resistance testing method for measuring rolling resistance of a tire based on a tangential force (F_x) acting on a tire axle upon the tire rotating by being pushed against an outer surface of a rotating drum, the method including the steps of:

a zero point adjustment step of adjusting a value of a component force meter to zero point after mounting the tire inflated on the tire axle;

55 a rolling resistance measurement step of measuring a tangential force (F_x) acting on the tire axle using the component force meter upon the tire rotating with a load by being pushed against the outer surface of the rotating drum; and a determination step including:

measuring a tangential force (F_{xA}) of the tire axle in a stop state of the tire being separated from the drum with no load, after the rolling resistance measurement step;
 comparing the tangential force (F_{xA}) with a previously determined threshold value (K_A); and
 determining the test as abnormal in case of the tangential force (F_{xA}) exceeding the threshold value (K_A).

5 **[0010]** In the tire rolling resistance testing method according to the invention, the tangential force (F_x) may be measured upon the tire rotating in a first direction with a load by being pushed against the outer surface of the rotating drum in the rolling resistance measurement.

10 **[0011]** In the tire rolling resistance testing method according to the invention, the rolling resistance measurement step may include a first rotation direction measurement step of measuring a tangential force (F_{x1}) from the tire rotating in a first direction, and a second rotation direction measurement step of measuring a tangential force (F_{x2}) from the tire rotating in a second direction, with a load by being pushed against the outer surface of the rotating drum.

15 **[0012]** In the tire rolling resistance testing method according to the invention, the rolling resistance measurement step may further include an intermediate determination step between the first rotation direction measurement step and the second rotation direction measurement step, and the intermediate determination step may include measuring a tangential force (F_{xB}) of the tire axle in a stop state of the tire being separated from the drum with no load, after the first rotation direction measurement step, comparing the tangential force (F_{xB}) with a previously determined threshold value (K_B), and stopping the test as abnormal in case of the tangential force (F_{xB}) exceeding the threshold value (K_B).

20 **[0013]** The second aspect in accordance with the invention provides a tire rolling resistance testing device for performing the rolling resistance testing method, wherein the device includes a determination means to determine a result of the test abnormal in case of the tangential force (F_{xA}) exceeding the threshold value (K_A).

Advantageous Effects of Invention

25 **[0014]** The present invention includes the determination step as described above. In the determination step, a tangential force F_{xA} of the tire axle in the stop state of the tire separated from the drum with no load, i.e., drift amount is measured after the rolling resistance measurement step. Then, the drift amount (the tangential force F_{xA}) is compared with a previously determined threshold value K_A , and the test is determined as abnormal when the drift amount exceeds the threshold value K_A .

30 **[0015]** That is, the present invention is possible to identify and exclude an abnormal measurement of rolling resistance value due to drift of the force component meter. Thus, the present invention may suppress decreases in reliability and accuracy of rolling resistance which are caused by abnormal measurement of rolling resistance. As a result, the present invention may improve measurement accuracy and reliability of rolling resistance.

35 Brief Description of Drawings

[0016]

40 FIG. 1 is a perspective view illustrating an embodiment of a testing device for carrying out the rolling resistance testing method of a tire of the present invention.

FIG. 2 is a conceptual diagram illustrating the rolling resistance testing method.

FIG. 3 is a flowchart illustrating the rolling resistance testing method.

FIG. 4 is a graph showing a relationship between a tangential force measured on the basis of the flow chart and an elapsed time of the test.

45 FIG. 5 is a graph illustrating an example of a method for calculating the rolling resistance.

FIG. 6 is a conceptual diagram illustrating a conventional rolling resistance test method by the force method.

Description of Embodiments

50 **[0017]** Hereinafter, an embodiment of the present invention will be described in detail. As illustrated in FIG. 1, a rolling resistance testing device 1 of a tire in accordance with the present embodiment (simply referred to as "rolling resistance testing device 1") includes a main body 1A and a determination unit 1B.

55 **[0018]** The main body 1A is configured to be able to measure rolling resistance F_r of a tire based on a tangential force F_x acting on a tire axle 3 when the tire is rotated by being pushed against an outer surface 2S of a drum 2 which is rotating. Specifically, the main body 1A includes the drum 2, a drum driving device 4, a tire holder 5 and a force component meter 6. The outer surface 2S of the drum 2 is configured as a road surface for the tire. The drum driving device 4 drives the drum 2 around its central axis. The tire holder 5 is configured to rotatably support the tire T and to be able to press the held tire T against the outer surface 2S of the drum 2 to rotate the tire T. The force component meter 6 is configured

to measure a tangential force F_x generating on the tire axle 3 of the tire T which is rotating. Note that the main body 1A may include an internal pressure adjustment device for adjusting the inner pressure of the tire T under measurement.

[0019] The drum driving device 4 includes a drum holder 7 and a motor (not illustrated). The drum holder 7 rotatably supports a central axle 2A of the drum 2. The motor drives the drum 2 rotationally through an output shaft coupled to the central axle 2A. Then, a speed V of the outer surface 2S of the drum 2 (i.e. a running speed of the tire T) can freely be adjustable by controlling the rotational speed of the motor.

[0020] The tire holder 5 includes a base 10, a movable table 11 and the tire axle 3. The movable table 11 is movably mounted on the base 10 in a drum radial direction. The tire axle 3 is arranged in parallel with the central axle 2A of the drum 2, and a first end of the tire axle 3 is supported by the movable table 11. Furthermore, a second end of the tire axle 3 is supposed to rotatably support the tire T. In this embodiment, the movable table 11 is configured as a lifting table that is movable up and down. Furthermore, the movable table 11 can support the tire T such that the center axis of the tire T is located within a vertical standard plane that passes the center axis of the drum 2. Accordingly, the tire holder 5 can vertically press the tire T mounted on the tire axle 3 with an arbitrary tire load against the outer surface 2S of the drum 3 by a downward movement of the movable table 11.

[0021] The force component meter 6, for example, may be fixed to a bearing of the tire axle 3, and is configured to be able to measure a tangential force F_x acting on the tire axle 3. In this embodiment, the force component meter 6 can measure a radial force F_z acting (i.e., vertical force) on the tire axle 3 in the radial direction of the drum, at the same time, in addition to the tangential force F_x . As the force component meter 6, a multi-component force meter such as a two-component force meter and the like can preferably be employed.

[0022] The determination unit 1B, for example, is configured as an arithmetic processing unit or a part of it, such as a computer and the like. Then, the determination unit 1B performs a comparison and determination in a determination step S3 of the rolling resistance testing method described below.

[0023] Next, as conceptually illustrated in FIG. 2, the rolling resistance testing method is to measure rolling resistance F_r of the tire T based on a tangential force F_x acting on the tire axle 3 when the tire T is rotating by being pushed against the outer surface 2S of the drum 2 which is rotating.

[0024] Specifically, as the flowchart illustrated in FIG. 3, the rolling resistance testing method includes a zero point adjustment step S1, a rolling resistance measurement step S2 and the determination step S3. In the zero point adjustment step S1, the component force meter 6 is adjusted so that the indication or output signal shows zero after mounting the tire T, which has already been inflated, on the tire axle 3.

[0025] Next, in the rolling resistance measurement step S2, the tire T is forced to rotate with a load by being pushed against the outer surface 2S of the drum 2 which is rotating, and then a tangential force F_x acting on the tire axle 3 is measured using the component force meter 6. In this embodiment, the rolling resistance measurement step S2 includes a first rotation direction measurement step S2a of measuring a tangential force F_{x1} from the tire rotating in a first direction in a loaded state, a second rotation direction measurement step S2c of measuring a tangential force F_{x2} from the tire rotating in a second direction in the loaded state and an intermediate determination step S2b therebetween.

[0026] Specifically, in the first rotation direction measurement step S2a, the following steps of (a) to (d) are sequentially conducted after the zero point adjustment step S1:

(a) applying a predetermined vertical load F_g to the tire T by pushing the tire T against the outer surface 2S of the drum 2 (e.g., 80% of the maximum load capacity) (Step a);

(b) measuring the tangential force F_{x1} in the loaded state under the vertical force F_g while being rotated the drum 2 in the first direction at a certain speed V (e.g., 80 km/h) after a warming-up running in a certain time T_s (e.g., 30 minutes) (Step b);

(c) measuring parasitic loss which is a tangential force F_{x1s} at a skim running state where the tire T is rotating while maintaining the above mentioned speed V with a skim load F_s (e.g., 0.1 kN) after reducing the vertical load F_g to the skim load F_s (Step c); and

(d) stopping the rotation of drum (Step d).

[0027] Note that the vertical force F_g , the skim load F_s , the speed V , the time T_s for warming-up running and the like are set in accordance with specifications of the rolling resistance test such as JIS Standard (JIS D4234) and International standard (ISO 28580) and the like.

[0028] Furthermore, in the intermediate determination step S2b, the following steps (e) and (f) are sequentially performed after the first rotation direction measurement step S2a:

(e) measuring drift amount F_{xB} which is a tangential force F_{xB} at a stop state of the tire T being separated from the drum 2 and loaded with no tire load (Step e); and

(f) comparing the tangential force (i.e., the drift amount) F_{xB} with a previously determined threshold value K_B and then determining either stopping the test as abnormal in case of the tangential force F_{xB} exceeding the threshold

value KB ($F_{xB} > KB$) or continuing the test as normal in case of the tangential force F_{xB} not exceeding the threshold value KB ($F_{xB} \leq KB$) (Step f).

[0029] Furthermore, in the second rotation direction measurement step S2c, the following steps of (g) to (j) are sequentially conducted after the intermediate determination step S2b:

(g) applying the above mentioned vertical load F_g to the tire T by pushing the tire T against the outer surface 2S of the drum 2 (Step g);

(h) measuring the tangential force F_{x2} in the loaded state under the vertical force F_g while being rotated the drum 2 in the second direction at the above mentioned speed V after a warming-up running in the above mentioned time T_s (Step h);

(i) measuring parasitic loss which is a tangential force F_{x2s} at the skim running state where the tire T is rotating while maintaining the above mentioned speed V with the above mentioned skim load F_s after reducing the vertical load F_g to the skim load F_s (step i); and

(j) stopping the rotation of drum (Step j).

[0030] Furthermore, in the determination step S3, the following steps (k) and (l) are sequentially performed after the rolling resistance measurement step S2 (i.e., after the second rotation direction measurement step S2c in this embodiment):

(k) measuring drift amount F_{xA} which is a tangential force F_{xA} at the stop state of the tire T being separated from the drum 2 and loaded with no tire load (Step k); and

(l) comparing the tangential force F_{xA} (i.e., the drift amount F_{xA}) with a previously determined threshold value K_A , and then determining the test as abnormal in case of the tangential force F_{xA} exceeding the threshold value K_A (Step l).

[0031] FIG. 4 illustrates a graph showing a relationship between the tangential force F_x measured on the basis of the flow chart and an elapsed time of the test. As illustrated in FIG. 4, in Step a, the tangential force F_x has not been generated since the drum 2 is not rotated. In Step b, the tangential force F_x is increasing according to increase of the speed, and then the tangential force F_x is stabilized during the warming-up running after reaching a predetermined speed V (e.g., 80 km/h). Furthermore, the tangential force F_{x1} is measured for about one minute during running after the warming-up. In Step c, the tangential force F_x decreases according to decrease of load from the vertical load F_g to the skim load F_s . Then, the tangential force F_{x1s} (i.e., parasite loss) is measured for about one minute during the skim running.

[0032] After stopping the rotation of the drum in Step d, Step e is subsequently performed. In the stop state with no load in Step e, the tangential force F_x has to be zero properly. Accordingly, the tangential force F_{xB} measured in Step e is a false output based on the drift (zero-point shifting) on the force component meter 6, and which is an error. Therefore, when the tangential force (the drift amount) F_{xB} is large, even when corrected, it lowers the accuracy and reliability of the measurement values. Thus, Step f of the present embodiment compares the tangential force F_{xB} (i.e., the drift amount) with a previously determined threshold value K_B , and then stops the test as abnormal in case of the tangential force F_{xB} exceeding the threshold value K_B . This makes it possible to find out an measurement abnormality due to drift quickly to reduce the waste of measuring time.

[0033] Furthermore, after applying the vertical load F_g in Step g, the tire T and the drum 2 start to rotate in the second direction. In Step h, the tangential force F_x is increasing according to increase of the speed, and then the tangential force F_x is stabilized during the warming-up running after reaching a predetermined speed V (e.g., 80 km/h). Note that the reason why the tangential force is not constant is an influence of drift of the force component meter 6. The tangential force F_{x2} is measured for about one minute during running after the warming-up. In Step i, the tangential force F_x decreases according to a decrease of load from the vertical load F_g to the skim load F_s . Then, the tangential force F_{x2s} (i.e., parasitic loss) is measured for about one minute during the skim running.

[0034] After stopping the rotation of the drum in Step j, Step k is subsequently performed. The tangential force F_{xA} measured in Step k, as same as the tangential force F_{xB} measured in Step e, is a false output based on the drift (zero-point shifting) on the force component meter 6. Therefore, when the axial force (the drift amount) F_{xA} is excessively large, even when corrected, it lowers the accuracy and reliability of the measurement values. Thus, Step l of the present embodiment compares the tangential force F_{xA} (i.e., the drift amount) with a previously determined threshold value K_A , and then determines the test as abnormal in case of the tangential force F_{xA} exceeding the threshold value K_A . This makes it possible to exclude the obtained rolling resistance F_r from the evaluation.

[0035] Although the threshold values K_A and K_B are not particularly limited, they are preferable to be set in consideration with a large number of tangential force F_{xA} and F_{xB} that is actually measured by the pre-test. Also, the comparison and determination in step l is carried out by the determination unit 1B.

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[0036] Furthermore, when $F_{xA} \leq KA$, the test is determined as normal, and the rolling resistance F_r is calculated based on the measured values of tangential force F_{x1} , tangential force F_{x1s} (i.e., parasitic loss), the tangential force F_{xB} (i.e., drift amount), the tangential force F_{x2} , the tangential force F_{x2s} (i.e., parasitic loss) and the tangential force F_{xA} (i.e., drift amount).

[0037] As for one example of a calculating method of the rolling resistance F_r , for example, the following equation could be employed in case that the measured period for the tangential force F_{x1s} (parasitic loss) approaches to the measured period for the tangential force F_{xB} (drift amount) and that the measured period for the tangential force F_{x2s} (parasitic loss) approaches to the measured period for the tangential force F_{xA} (drift amount), as shown in FIGs. 4 and 5.

$$F_r = \{(F_1 + F_2) / 2\} \times \{(R + r) / R\}$$

$$F_1 = \{F_{x1} - F_{xB} \cdot (t_1 / t_2)\} - \{F_{x1s} - F_{xB}\}$$

$$F_2 = \{F_{x2} + F_{xA} \cdot (t_3 / t_4)\} - \{F_{x2s} + F_{xA}\}$$

[0038] Here, t_1 is an elapsed time at the time of measurement of the tangential force F_{x1} , t_2 is an elapsed time at the time of measurement of the tangential force F_{x1s} (parasitic loss), t_3 is an elapsed time at the time of measurement of the tangential force F_{x2} , and t_4 is an elapsed time at the time of measurement of the tangential force F_{x2s} (parasitic loss). Furthermore, in the equation, F_1 is a tangential force that is corrected based on the parasitic loss and the drift amount in the first rotation direction measurement step $S2a$, F_2 is a tangential force that is corrected based on the parasitic loss and the drift amount in the second rotation direction measurement step $S2c$, R is a radius of the drum 2 as shown in FIG. 2, r is a distance between the axial center of the tire axle 3 during running and the outer surface 2S of the drum 2 as shown in FIG. 2.

[0039] As another example of the rolling resistance measurement step $S2$, the intermediate determination step $S2b$ may be omitted, i.e., the rolling resistance measurement step $S2$ may consist of the first rotation direction measurement step $S2a$ and the second rotation direction measurement steps $S2b$. In this case, the rolling resistance F_r can be calculated using the following equation;

$$F_r = \{(F_1 + F_2) / 2\} \times \{(R + r) / R\}$$

$$F_1 = \{F_{x1} - F_{xA} \cdot (t_1 / t_4)\} - \{F_{x1s} - F_{xA} \cdot (t_2 / t_4)\}$$

$$F_2 = \{F_{x2} + F_{xA} \cdot (t_3 / t_4)\} - \{F_{x2s} + F_{xA}\}$$

[0040] Furthermore, yet another example of the rolling resistance measurement step $S2$, the intermediate determination step $S2b$ and the second rotation direction measurement step $S2b$ may be omitted, i.e., the rolling resistance measurement step $S2$ may consist of only the first rotation direction measurement step $S2a$. In this case, the rolling resistance F_r can be calculated using the following equation.

$$F_r = \{F_1 \times \{(R + r) / R\}\}$$

$$F_1 = \{F_{x1} - F_{xB} \cdot (t_1 / t_2)\} - \{F_{x1s} - F_{xB}\}$$

$$F_{xB} = F_{xA}$$

[0041] In any of the above examples, since the determination step $S3$ can identify the abnormalities of the test, if there

is an abnormality, the obtained rolling resistance F_r can be excluded from the evaluation to improve the measurement accuracy and reliability of rolling resistance.

[0042] While a particularly preferred embodiments of the present invention have been described in detail, the present invention is not be limited to the embodiments as shown, but it may be carried out by modifying to various aspects.

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Reference Signs List

[0043]

- 10 1 Rolling resistance testing device
- 1B Determination unit
- 2 Drum
- 2S Outer surface
- 3 Tire axle
- 15 6 Force component meter
- S1 Zero adjustment step
- S2 Rolling resistance measurement step
- S2a First rotation direction measurement step
- S2b Intermediate determination step
- 20 S2c Second rotation direction measurement step
- S3 Determination step
- T Tire

25 **Claims**

1. A tire rolling resistance testing method for measuring rolling resistance of a tire based on a tangential force (F_x) acting on a tire axle upon the tire rotating by being pushed against an outer surface of a rotating drum, the method comprising the steps of:

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- a zero point adjustment step of adjusting a value of a component force meter to zero point after mounting the tire inflated on the tire axle;
- a rolling resistance measurement step of measuring a tangential force (F_x) acting on the tire axle using the component force meter upon the tire rotating with a load by being pushed against the outer surface of the rotating drum; and
- 35 a determination step comprising:

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- measuring a tangential force (F_{xA}) of the tire axle in a stop state of the tire being separated from the drum with no load, after the rolling resistance measurement step;
- 40 comparing the tangential force (F_{xA}) with a previously determined threshold value (KA); and
- determining the test as abnormal in case of the tangential force (F_{xA}) exceeding the threshold value (KA).

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2. The tire rolling resistance testing method according to claim 1, wherein the tangential force (F_x) is measured upon the tire rotating in a first direction with a load by being pushed against the outer surface of the rotating drum in the rolling resistance measurement.

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3. The tire rolling resistance testing method according to claim 1, wherein the rolling resistance measurement step comprises a first rotation direction measurement step of measuring a tangential force (F_{x1}) from the tire rotating in a first direction, and a second rotation direction measurement step of measuring a tangential force (F_{x2}) from the tire rotating in a second direction, with a load by being pushed against the outer surface of the rotating drum.

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4. The tire rolling resistance testing method according to claim 3, wherein the rolling resistance measurement step further comprises an intermediate determination step between the first rotation direction measurement step and the second rotation direction measurement step, and the intermediate determination step comprises measuring a tangential force (F_{xB}) of the tire axle in a stop state of the tire being separated from the drum with no load, after the first rotation direction measurement step, comparing the tangential force (F_{xB}) with a previously

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determined threshold value (KB), and stopping the test as abnormal in case of the tangential force (FxB) exceeding the threshold value (KB).

- 5 **5.** A tire rolling resistance testing device for performing the rolling resistance testing method according to any one of claims 1 to 4,
 wherein the device comprises a determination means to determine a result of the test abnormal in case of the tangential force (FxA) exceeding the threshold value (KA).

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FIG.1

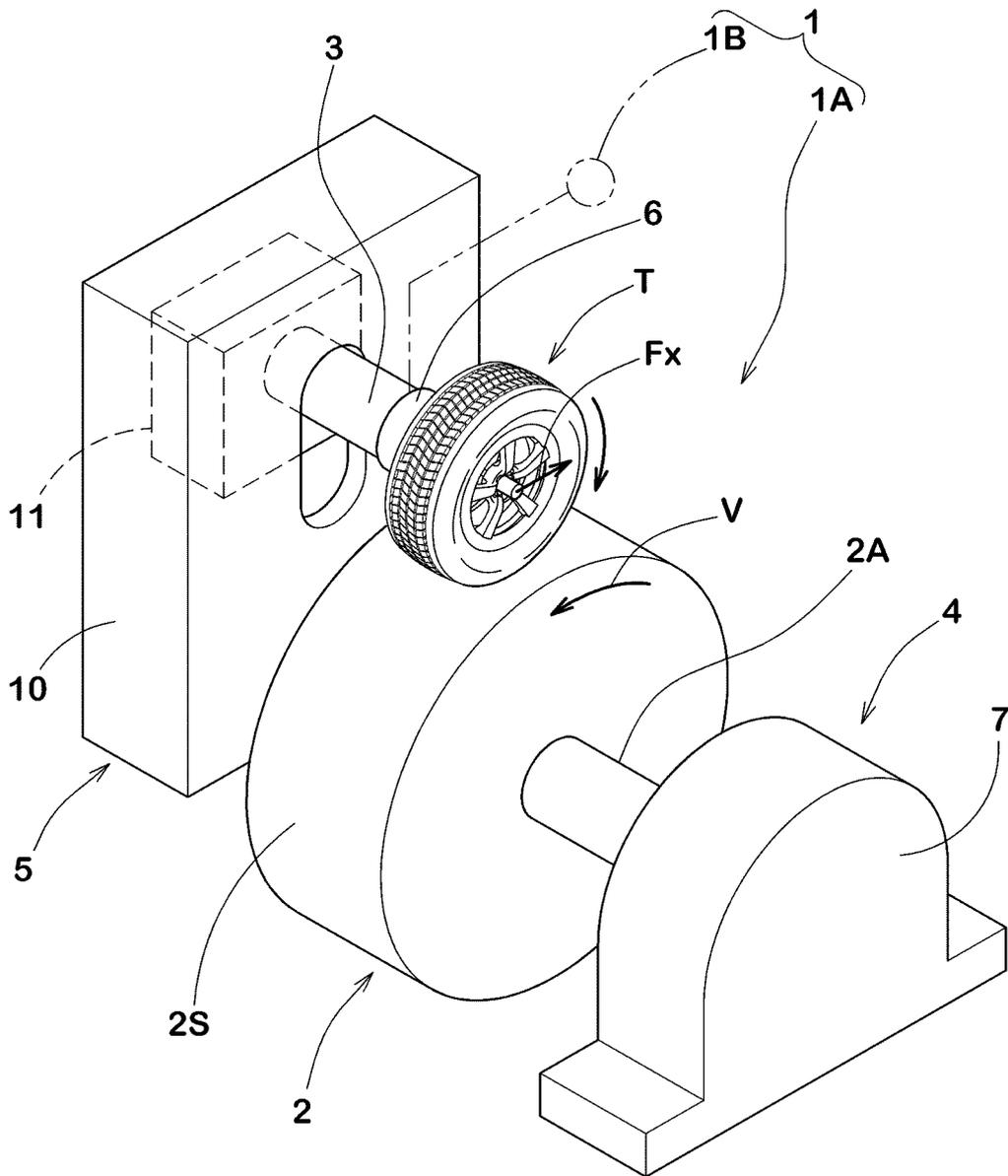


FIG.2

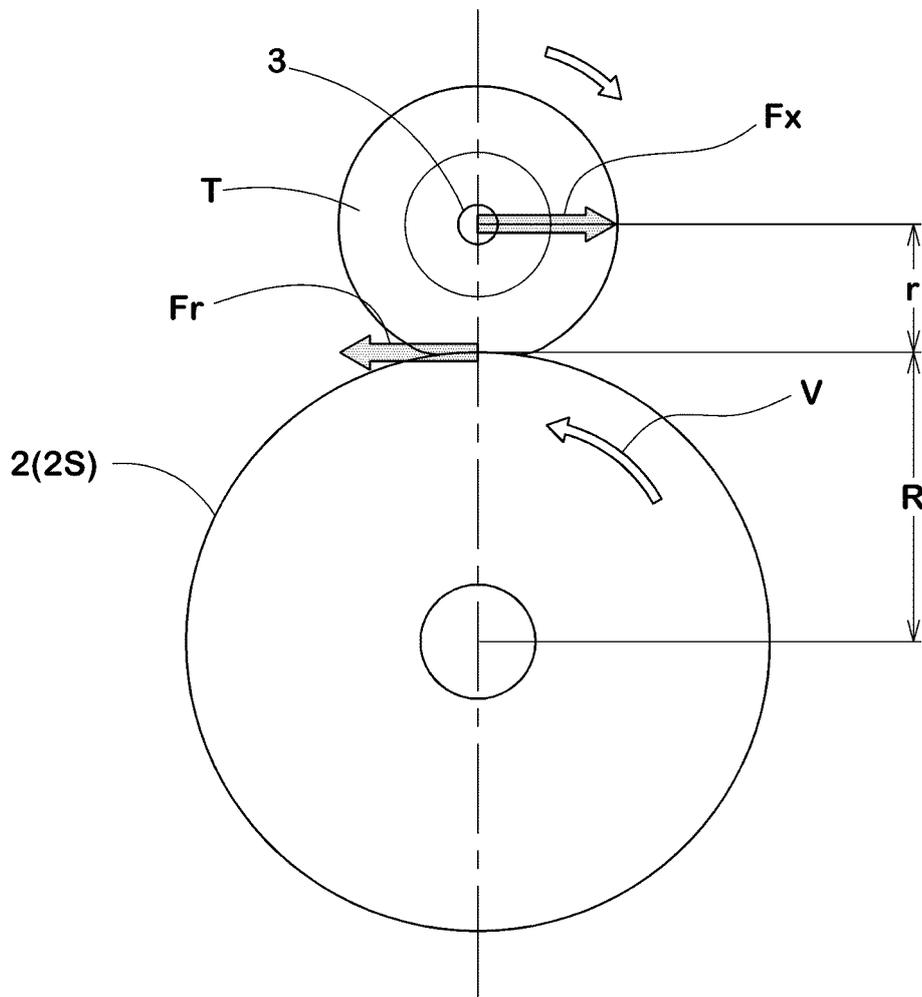


FIG.3

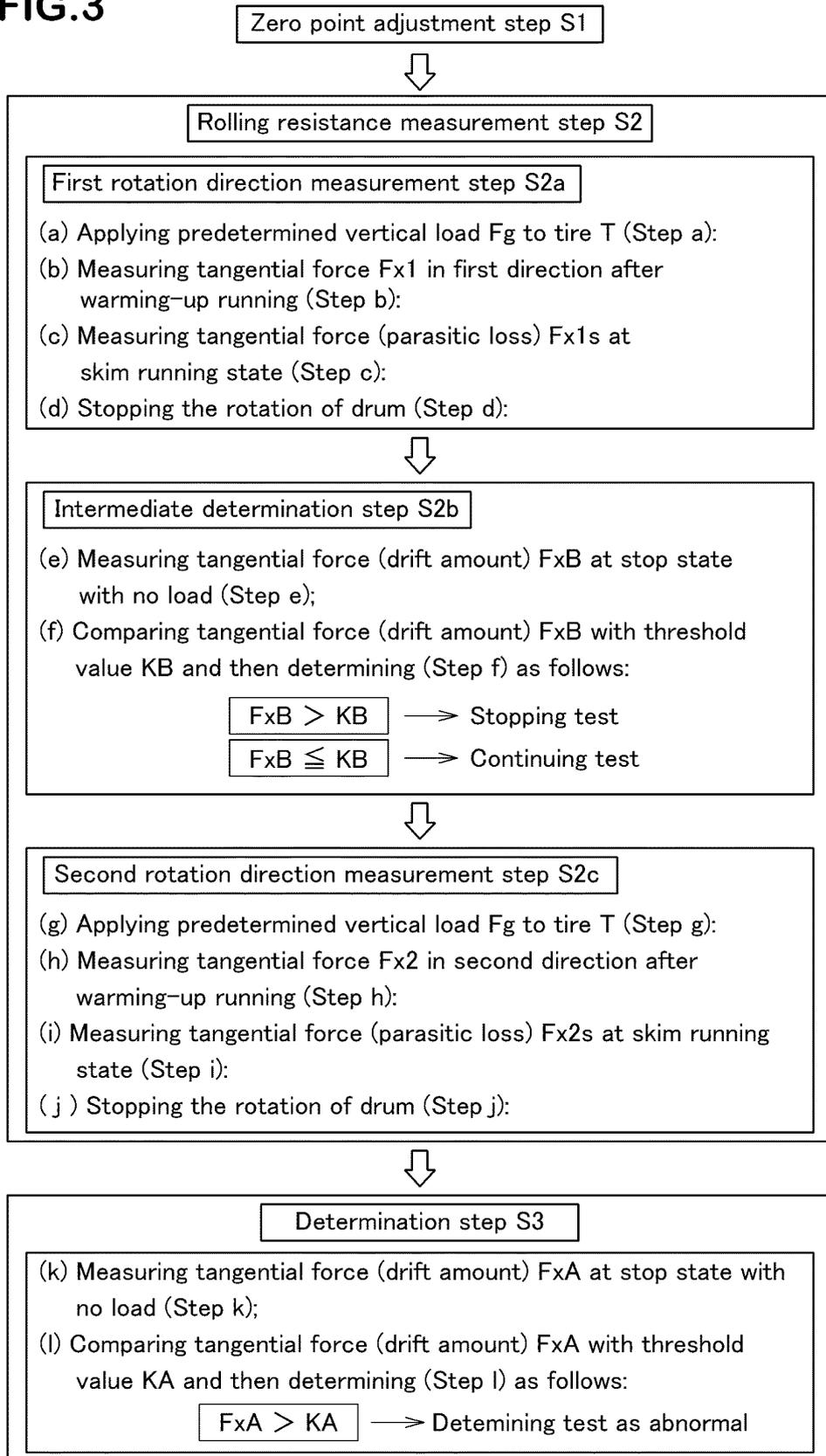


FIG.4

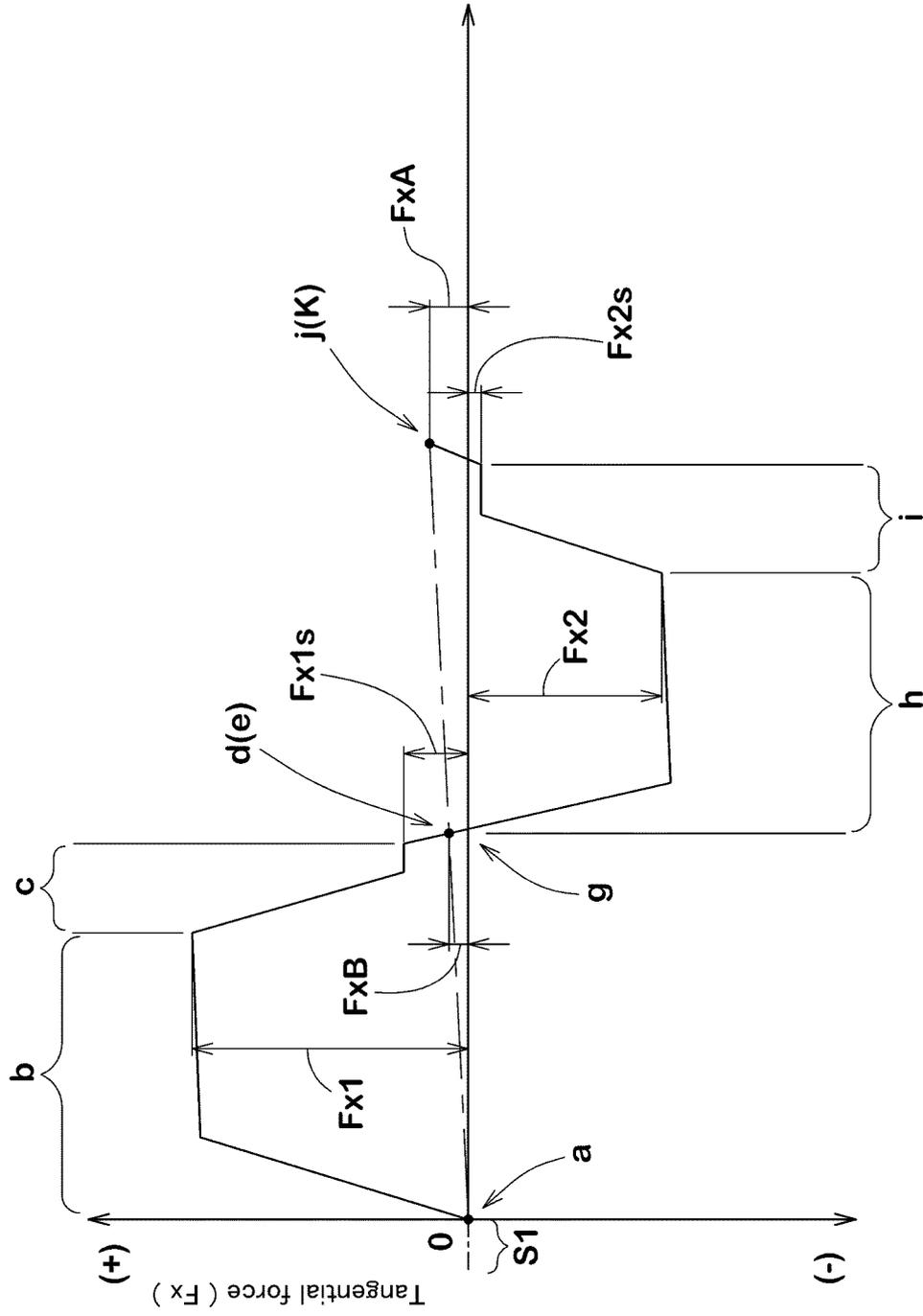


FIG.5

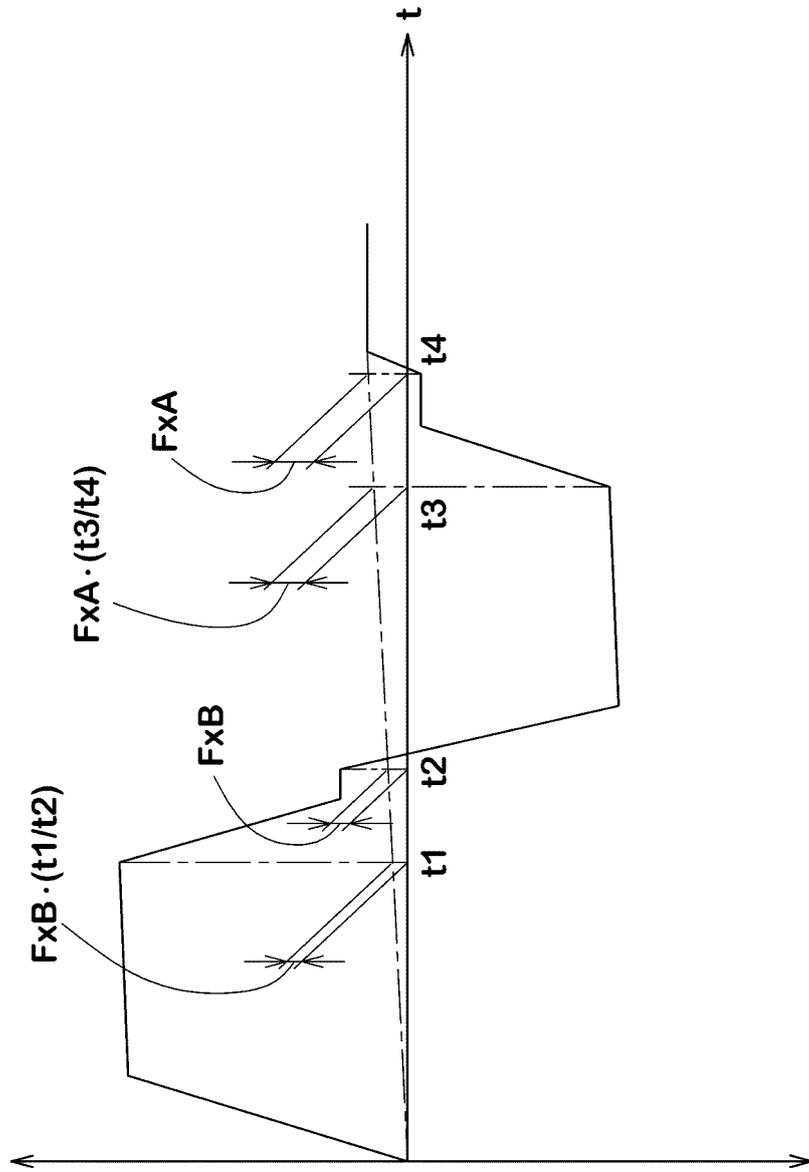
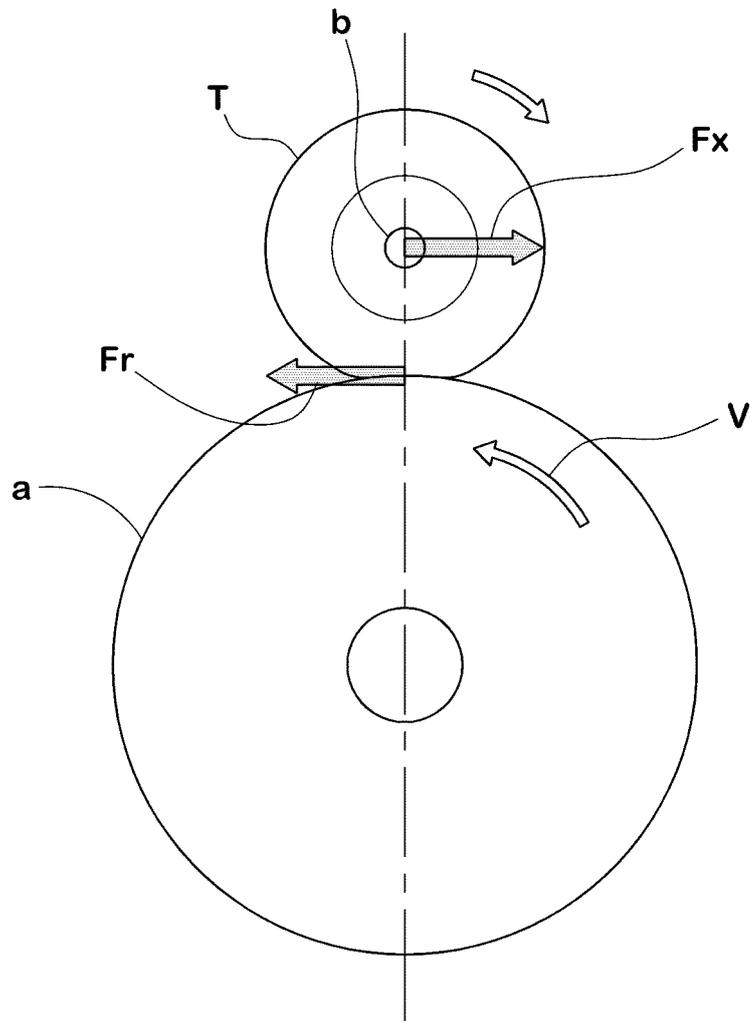


FIG.6



INTERNATIONAL SEARCH REPORT

International application No.

PCT/JP2014/078918

A. CLASSIFICATION OF SUBJECT MATTER

G01M17/02(2006.01)i, B60C19/00(2006.01)i

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

G01M17/02, B60C19/00

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Jitsuyo Shinan Koho	1922-1996	Jitsuyo Shinan Toroku Koho	1996-2015
Kokai Jitsuyo Shinan Koho	1971-2015	Toroku Jitsuyo Shinan Koho	1994-2015

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	WO 2013/191055 A1 (Kobe Steel, Ltd.), 27 December 2013 (27.12.2013), paragraphs [0020] to [0028], [0048] to [0051] & JP 2014-2079 A & TW 201418684 A	1-5
A	JP 8-268243 A (Sumitomo Electric Industries, Ltd.), 15 October 1996 (15.10.1996), paragraphs [0016] to [0036] (Family: none)	1-5
A	JP 2006-300613 A (The Yokohama Rubber Co., Ltd.), 02 November 2006 (02.11.2006), paragraphs [0021] to [0026] (Family: none)	1-5

 Further documents are listed in the continuation of Box C.
 See patent family annex.

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Date of the actual completion of the international search
07 January 2015 (07.01.15)Date of mailing of the international search report
20 January 2015 (20.01.15)Name and mailing address of the ISA/
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C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

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REFERENCES CITED IN THE DESCRIPTION

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- JP S5651641 B [0007]